

Work Order ID 70881

Thursday, June 16, 2011 3:24:40 PM



Page 1

Item ID: D2744

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/16/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

6-16-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2744	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

B11-7-5

FLOW CNC Waterjet

1-Cut as per Dwg D2744

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

2-Deburr if necessary

(32)

5050 - 080

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B11-7-5

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 units

Count

(x32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70881

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Item ID: D2744

Accept

Revision ID:

Item Name: Cap

Start Date: 6/16/2011 Start Qty: 24.00

Required Date: 6/23/2011 Req'd Qty: 24.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>2602</u>	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF
11-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 70881

Parent Item: D2744

Parent Item Name: Cap



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP ☐ C ☐ 03.01.17 ☐ Reformat; Dwg revised ☐ KJ/RF
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP Rev:E As per Rev C 07-07-28 JLM Verified By: ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080 5052-H32 .080 Sheet		Purchased	No			100	sf	69.0000	0.1823	4.605474	6.		

B11-7-5

Location	Loc Qty	Loc Code
MAT22	69	
100742	42	
100947	25	
19729	2	

100947

32

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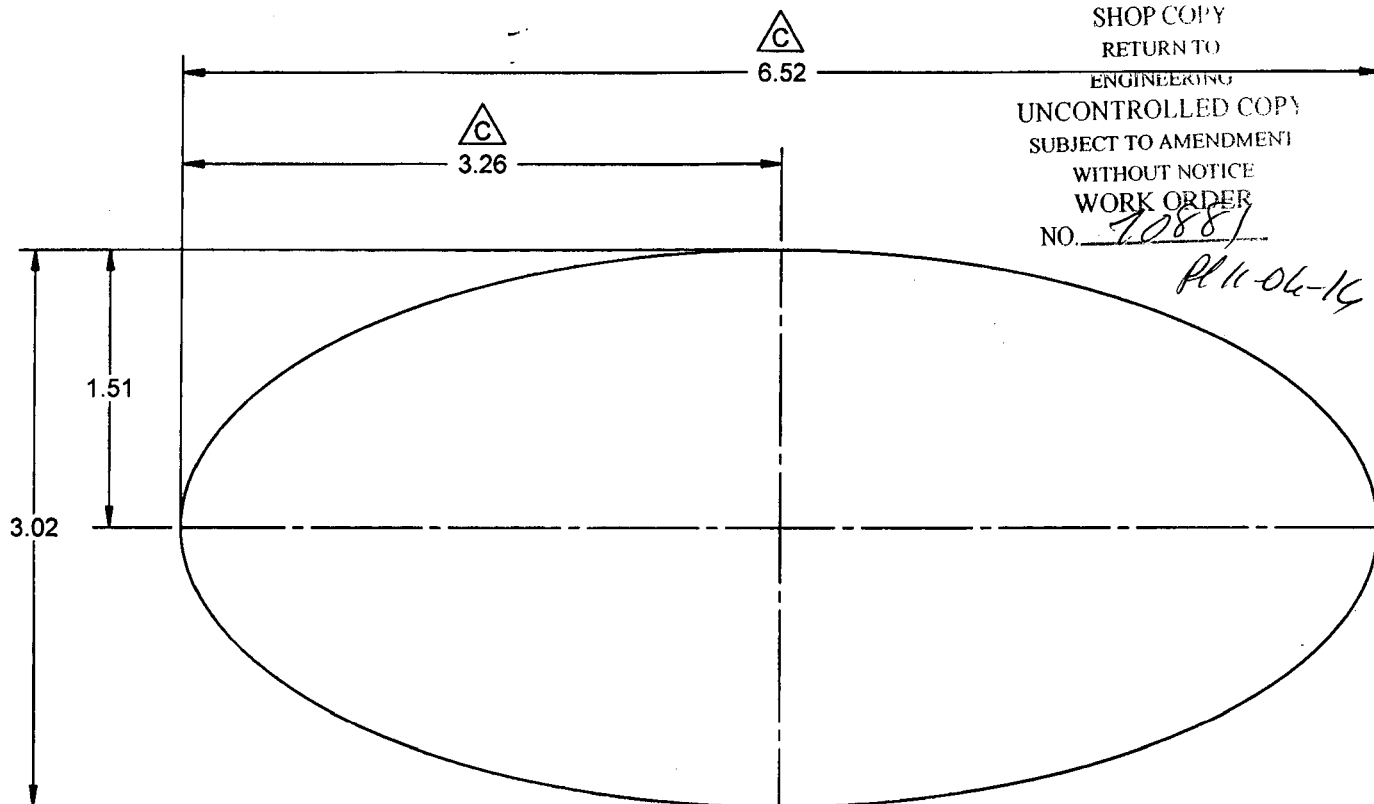
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05	TITLE CAP	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02 JH**D2744 CAP****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.080) OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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